

Work Order ID 78705

78705

Page 1

January-13-12 7:05:03 AM

Item ID: D412-694-01

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.S

Date: 12/01/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

~~AA~~ ~~D412-694~~

Rev C1

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Issue red decal labels for D412-694-01

CHG005

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78705

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Page 2

January-13-12 7:05:03 AM

Item ID: D412-694-01

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

Small Fab

COMPOSITE ASSEMBLY

Memo

0.00

Small Fab

✓ D412-694-01 Drill Process
1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P).

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet.

✓ Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P).

Note: D3151-041 orientation in the door.

✓ 3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).

✓ 4- Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2/-T3 as per Dwg D412-694 page 2.

Note: The (12) holes for the (6) nut plates can not be less than 0.290" from inside edge.

✓ 5- Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.

✓ 6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).

13-0507

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78705

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January-13-12 7:05:03 AM

Item ID: D412-694-01

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).

8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.

9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-041 cover.

120

0.00

120

Small Fab

COMPOSITE ASSEMBLY

Memo

0.00

Small Fab

1- Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).

2- Sand flush excess Hysol around the insert on both doors.

13-05-12

W/O:		WORK ORDER CHANGES					
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Page 4

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Item ID: D412-694-01

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Setup Start

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NS2

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

Inspect that inserts are flush with the surface.

140

0.00

140

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

1. Apply Primer filler and reducer around the inserts on both doors.

A/R ~~11845~~ Primer Filler
A/R ~~12356~~ Reducer

Batch: ~~124594~~
Batch: ~~125055~~

150

0.00

150

QC14- Inspect Spray Paint

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78705***78705***

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Item ID: D412-694-01

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Small Fab

Small Fab

COMPOSITE ASSEMBLY

Memo

0.00

D412-694-01 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-041/-043.


2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

3- Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

 13-06-18

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78705

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Item ID: D412-694-01 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door Assembly
 Start Date: 12/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 26/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

① B 10.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 78705

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January-13-12 7:05:03 AM

Item ID: D412-694-01

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180	COMPOSITE ASSEMBLY					1	0	R.H	
Small Fab	Memo	0.00							
Small Fab	<div>✓ D412-694-01 Assembly Process (Continued)</div> <div>1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N). Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.</div> <div>✓ 2- Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.</div> <div>✓ 3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")</div> <div>✓ 4- Open 15/64" (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.</div> <div>✓ 5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.</div> <div>6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation. A/R RTV732 Clear Batch: <u>M126271</u> Expiry Date: <u>N/A</u></div> <div>7- Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2</div>								

D3116-9-0770

D3144-13

✓ correct

10/1/14

1 0 R.H. *[Signature]* Aug. 12/11

[Handwritten notes and signatures]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78705

78705

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January-13-12 7:05:03 AM

Item ID: D412-694-01 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Door Assembly
Start Date: 12/01/2012 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 26/01/2012 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	(view G-G and NN-NN).								
	8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control	Install door on mock up helicopter to insure proper fil and function								
200		0.00							
200	COMPOSITE ASSEMBLY								
Small Fab	Memo	0.00							
Small Fab	1- Finish installing D3163-041 in the door. 2- Install red decal before closing cover.								

1 2. H 2/23/14
① 14-08-25 DAS 9 9-89
14-10-22
Pto

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
14-10-20	200	install up trim using N4539/BGP washer <u>B 124605</u> x 26 N45388-6-8P screw <u>B 123900</u> x 26 ALS4-632-80 rimnut <u>B 112495</u> x 26	BT 14-10-20	14.10.20	1	A.P. 14.10.20		
14-10-20	200	replace AN525-10R8 screws with 1-10R8 on panel D3163-041 8 locations AN525-10R8 <u>B 129163</u> x 8 replace AN525-10R6 with 1-10R7 re-use 10R7's from 10R8 locations + pull 2 new 10R7 total 10 locations AN525 10R7 <u>B 129700</u> x 2	BT 14-10-20	A.P. 14.10.20	1	A.P. 14.10.20		

Part No: _____ PAR #: _____ Fault Category: Instructions incomplete/incomplete NCR: Yes No DQA: AA Date: 14/12/11
Doc/data
Resolution: rework Disposition: rework QA: N/C Closed: 8/12/10 Date: 14/12/10

NCR: 14-11-13		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
14-10-22	200	no documentation supporting installation of URP trim	A.P. 14.10.22	trim + install up trim to be as aesthetically pleasing as possible using above mentioned hardware	BT 14-10-22	5 14/10/23	NA 14/10/23	5 14/10/23

NOTE: Date & initial all entries

Work Order ID 78705***78705***

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Item ID: D412-694-01

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O ✓	0.00							
210									
QC	Memo	0.00							
Quality Control									
220	Identify as per dwg & Stock Location: <u>78704</u>	0.00							
220									
Packaging	Memo	0.00							
Packaging									
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

MCS 14-10-27

N 14.10.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A 05.12.09 New Issue KJ/RF
IPP Rev: B 06.04.18 New dwg rev. ecn781 EC
IPP Rev: C 06.07.11 Revised per B24660 KJ
IPP Rev:D 08-08-27 replace QC5 to QC14 seq.7 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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NAS43DD3-14

Purchased

No

120

Each

76.0000

6

6

NAS43DD3-14

Spacer

**

Location

Loc Qty

Loc Code

ST278

76

113368

34

19347

42

80-005-2-8

Purchased

No

160

Each

60.0000

55

55

80-005-2-8

Insert

**

Location

Loc Qty

Loc Code

ST379

120273

60

113109

60

AN525-10R6

Purchased

No

160

Each

44.0000

12

12

AN525-10R6

Screw

**

Location

Loc Qty

Loc Code

ST346

44

118757

23

119309

21

120910

12

13-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN525-10R7

Purchased

No

160

Each

225.0000

8

8

AN525-10R7

Screw

**

Location

Loc Qty

Loc Code

ST345

125388

225

115371

25

116737

100

118686

100

8

13-05-07

AN960JD10L

NAS1149D0332J

Purchased

No

160

Each

0.0000

18

18

*AN960.ID10I *

Washer

125268

**

18

13-05-07

AN960JD10LL

Purchased

No

160

Each

3,641.000

15

15

*AN960.ID10I I *

Washer

**

Location

Loc Qty

Loc Code

ST337A

3641

19085

400

19600

3241

15

13-05-07

AN960JD416L

NAS1149D0416J

Purchased

No

160

Each

8.0000

6

6

*AN960.ID416I *

Washer

**

Location

Loc Qty

Loc Code

FP002

123741

8

110153

8

6

13-05-07

AN960JD8

NAS1149DN832

Purchased

No

160

Each

0.0000

6

6

AN960.ID8

Washer

**

123348

6

13-05-07

January-13-12 7:05:08 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

BSP45

Purchased

No

160

Each

177.0000

79

79

RSP45

Commercial Rivet

**

Location

Loc Qty

Loc Code

ST284

177

118614

177

79

13-05-07

BSP46

Purchased

No

160

Each

306.0000

6

6

RSP46

Commercial rivet

**

Location

Loc Qty

Loc Code

ST284

306

101237

6

112540

300

6

13-05-07

D3110-5

Manufactured

No

160

Each

1.0000

1

1

D3110-5

Handle Assembly

**

Location

Loc Qty

Loc Code

ST026

1

78241

1

1

13-05-07

D3115-1

Manufactured

No

160

Each

2.0000

1

1

D3115-1

Bracket

**

Location

Loc Qty

Loc Code

ST026

2

82774

2

1

13-05-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3116-7 Manufactured No

160 f

503.3340 5.6666 5.6666

D3116-7

Seal

**

Location

Loc Qty

Loc Code

ST408

503.334

27239

3.334

65117

500

D3116-9 Manufactured No

160 f

458.1634 6.4166 6.4166

D3116-9

Seal

**

Location

Loc Qty

Loc Code

ST408

458.1634

39182

450.1634

57495

8

D3121-041 Manufactured No

160 Each

1.0000 3 3

D3121-041

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST235

1

50441

1

101711

160 Each

2.0000 1 1

D3121-043 Manufactured No

D3121-043

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST235

2

50279

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3122-1
Lever
Manufactured No 160 Each 6.0000 1 1
**

D3122-1

Location Loc Qty Loc Code

ST027

6

65171

6

1 13-05-07

D3123-1
Cam
Manufactured No 160 Each 218.0000 2 2
**

D3123-1

Location Loc Qty Loc Code

Mezz

218

1053617

218

2 13-05-07

D3124-1
Hook
Manufactured No 160 Each 83.0000 1 1
**

D3124-1

Location Loc Qty Loc Code

CA

83

1053617

83

1 13-05-07

D3124-2
Hook
Manufactured No 160 Each 82.0000 1 1
**

D3124-2

Location Loc Qty Loc Code

CA

82

1053617

82

1 13-05-07

D3126-1
Bracket
Manufactured No 160 Each 14.0000 1 1
**

D3126-1

Location Loc Qty Loc Code

ST027

14

70079

14

1 13-05-07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3126-3 Manufactured No

160 Each 6.0000 1 1

D3126-3

Bracket

**

14-08-17

Location

Loc Qty

Loc Code

CA

1

55148

1

ST027

5

66256

5

113689

D3126-5 Manufactured No

160 Each 4.0000 5 5

D3126-5

Bracket

**

Location

Loc Qty

Loc Code

ST027

4

50345

4

78711

5

13-05-07

D3132-041 Manufactured No

160 Each 28.0000 1 1

D3132-041

Rod Weldment

**

Location

Loc Qty

Loc Code

Mezz

28

1053617

28

1

13-05-07

D3133-042 Manufactured No

160 Each 20.0000 1 1

D3133-042

Rod Weldment

**

Location

Loc Qty

Loc Code

CA

20

1053617

20

1

13-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3135-041	Manufactured	No	160	Each	1.0000	1	1	
D3135-041								
Handle Weldment								
						**	1	13-05-07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST235A

1

57761

1

D3137-045	Manufactured	No	160	Each	3.0000	1	1	
D3137-045								
Bracket Assembly								
						**		

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST235B

80099

3

53040

3

D3138-1	Manufactured	No	160	Each	0.0000	1	1	
D3138-1								
Cover								
						**	1	13-05-07

78739

D3139-1	Manufactured	No	160	Each	6.0000	1	1	
D3139-1								
Guard								
						**		

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA

96268

6

24700

6

D3139-3	Manufactured	No	160	Each	3.0000	1	1	
D3139-3								
Guard								
						**		

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST027

96405

3

63926

3

D3140-05	Manufactured	No	160	Each	0.0000	1	1	
D3140-05								
Door								
						**	1	13-05-07

78940

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3141-1 Manufactured No

160 Each 9.0000 2 2

D3141-1

Spring

**

Location

Loc Qty

Loc Code

ST028

9

52985

3

63507

6

D3144-109 Manufactured No

160 Each 4.0000 1 1

D3144-109

Doubler

**

Location

Loc Qty

Loc Code

CA

4

80273

4

D3144-111 Manufactured No

160 Each 0.0000 1 1

D3144-111

Doubler

**

D3144-13 Manufactured No

160 Each 4.0000 1 1

D3144-13

Doubler

**

Location

Loc Qty

Loc Code

CA

4

67799

4

D3144-3 Manufactured No

160 Each 4.0000 1 1

D3144-3

Doubler

**

Location

Loc Qty

Loc Code

ST241A

4

67800

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3148-1 Manufactured No

160 Each

174.0000

2 2

D3148-1

Clevis

**

Location

Loc Qty

Loc Code

Mezz

174

1053617

174

D3151-041 Manufactured No

160 Each

9.0000

1 1

D3151-041

Doubler Assembly

**

Location

Loc Qty

Loc Code

CA

9

39186

8

50294

1

D3152-041 Manufactured No

160 Each

3.0000

1 1

D3152-041

Bracket Assembly

**

Location

Loc Qty

Loc Code

CA

3

25284

3

D3155-041 Manufactured No

160 Each

10.0000

1 1

D3155-041

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST030

10

53041

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3155-042

Manufactured No

160 Each

4.0000

1 1

D3155-042

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST030

94605
56141

4
4

1 13-05-07

D3156-1

Manufactured No

160 Each

6.0000

2 2

D3156-1

Bracket

**

Location

Loc Qty

Loc Code

ST030

50297

6
6

2 13-05-07

D3162-041

Manufactured No

160 Each

7.0000

10 10

D3162-041

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST031

78709
50370

7
7

10 13-05-07

D3162-043

Manufactured No

160 Each

6.0000

1 1

D3162-043

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST031

36949

6
6

1 13-05-07

D3162-044

Manufactured No

160 Each

11.0000

1 1

D3162-044

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST031

36734

11
11

1 13-05-07

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3163-041 Manufactured No

160 Each 2.0000 1 1

D3163-041

Cover Assembly

**

1 ~~13~~ 13-05-07

Location

Loc Qty

Loc Code

ST241A

2

57570

2

D3183-041 Manufactured No

160 Each 0.0000 1 1

D3183-041

Bracket Assembly

**

1 ~~13~~ 13-05-07

78751

D3203-1 Manufactured No

160 Each 23.0000 1 1

D3203-1

Handle

**

Location

Loc Qty

Loc Code

ST240

23

97914

65003

1

69020

8

73552

14

D3308-1 Manufactured No

160 Each 1.0000 2 2

D3308-1

Doubler

**

1 ~~13~~ 13-05-07

Location

Loc Qty

Loc Code

ST047

1

78712

53028

1

M7885/2-4-3 Purchased No

160 Each 530.0000 12 12

M7885/2-4-3

Rivet

**

2 ~~13~~ 13-05-07

Location

Loc Qty

Loc Code

ST393

530

107376

530

12 ~~13~~ 13-05-07

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

M7885/3-4-4

Purchased

No

160

Each

321.0000

12

12

M7885/3-4-4

**

Rivets

Location

Loc Qty

Loc Code

ST393

321

108077

321

MS20392-2C17

Purchased

No

160

Each

186.0000

2

2

MS20392-2C17

**

Pin

Location

Loc Qty

Loc Code

ST316

186

18949

186

MS20392-2C9

Purchased

No

160

Each

6.0000

2

2

MS20392-2C9

**

Pin

Location

Loc Qty

Loc Code

ST315

6

120521

6

MS20392-3C21

Purchased

No

160

Each

19.0000

2

2

MS20392-3C21

**

Pin

Location

Loc Qty

Loc Code

ST316

19

104156

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-3

Purchased

No

160

Each

3,331.000

8

8

MS20426AD3-3

Rivet

Location

Loc Qty

Loc Code

ST316

123352

3331

119109

2828

19099

503

8

13-05-07

MS20426AD4-5

Purchased

No

160

Each

5,232.000

4

4

MS20426AD4-5

Rivet

Location

Loc Qty

Loc Code

Mezz

165

6733

165

ST317

5067

6874

5067

4

13-05-07

MS21042L08

Purchased

No

160

Each

394.0000

6

6

MS21042L08

Nut

Location

Loc Qty

Loc Code

ST300

394

120071

94

120142

300

123900

6

13-05-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

160

Each

7,809.000

4

4

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

124231

7809

117441

67

117601

342

118451

133

119017

2267

119075

5000

4

13-05-07

MS21072-L3

Purchased

No

160

Each

24.0000

4

4

MS21072-L3

Nutplate

**

Location

Loc Qty

Loc Code

ST302

121068

24

118378

24

4

13-05-07

MS24665-151

Purchased

No

160

Each

351.0000

6

6

MS24665-151

Cotter Pin

**

Location

Loc Qty

Loc Code

ST309

122802

351

17566

351

124859

160

Each

575.0000

4

4

MS24693-S271

Purchased

No

MS24693-S271

Screw

**

Location

Loc Qty

Loc Code

ST288

575

14478

575

4

13-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS24694-C5

Purchased

No

160

Each

65.0000

4

4

MS24694-C5

Screw

Location

Loc Qty

Loc Code

ST289

65

106815

65

4 ~~13~~ 13-05-07

MS24694-S5

Purchased

No

160

Each

572.0000

6

6

MS24694-S5

Screw

Location

Loc Qty

Loc Code

ST289

572

18949

136

19073

436

6 ~~13~~ 13-05-07

MS24694-S50

Purchased

No

160

Each

146.0000

18

18

MS24694-S50

Screw

Location

Loc Qty

Loc Code

ST289

146

116900

1

118078

45

119124

100

18 ~~13~~ 13-05-07

MS24694-S98

Purchased

No

160

Each

46.0000

4

4

MS24694-S98

Screw

Location

Loc Qty

Loc Code

ST289A

46

116582

21

119436

25

122441

4 ~~13~~ 13-05-07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-13-12 7:05:10 AM

Page 16

Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-05

Purchased

No

160

Each

107.0000

2

2

MS27039-1-05

Screw

**

Location

Loc Qty

Loc Code

ST291

124555

107

3501

107

2

13-05-07

MS27039-1-06

Purchased

No

160

Each

879.0000

14

14

MS27039-1-06

Screw

**

Location

Loc Qty

Loc Code

ST291

104289

879

879

14

13-05-07

MS27039-1-08

Purchased

No

160

Each

977.0000

13

13

MS27039-1-08

Screw

**

Location

Loc Qty

Loc Code

ST291

124326

977

117423

77

118910

26

119075

374

119109

500

13

13-05-07

MS35275-233

Purchased

No

160

Each

66.0000

2

2

MS35275-233

Screw

**

Location

Loc Qty

Loc Code

ST295

103641

66

11822

20

46

2

13-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-13-12 7:05:10 AM

Page 17

Work Order ID: 78705

78705

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS35649-264

Purchased

No

160

Each

52.0000

2

2

MS35649-264

Nut

**

Location

Loc Qty

Loc Code

ST296

52

52

11822

MS35650-3252

Purchased

No

160

Each

37.0000

2

2

MS35650-3252

Nut

**

Location

Loc Qty

Loc Code

ST296

37

37

10372

MS51859-7

Purchased

No

160

Each

12.0000

2

2

MS51859-7

Washer

**

Location

Loc Qty

Loc Code

ST296

12

12

111193

NAS43DD3-10

Purchased

No

160

Each

104.0000

7

7

NAS43DD3-10

Spacer

**

Location

Loc Qty

Loc Code

ST278

104

9

19185

19347

95

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

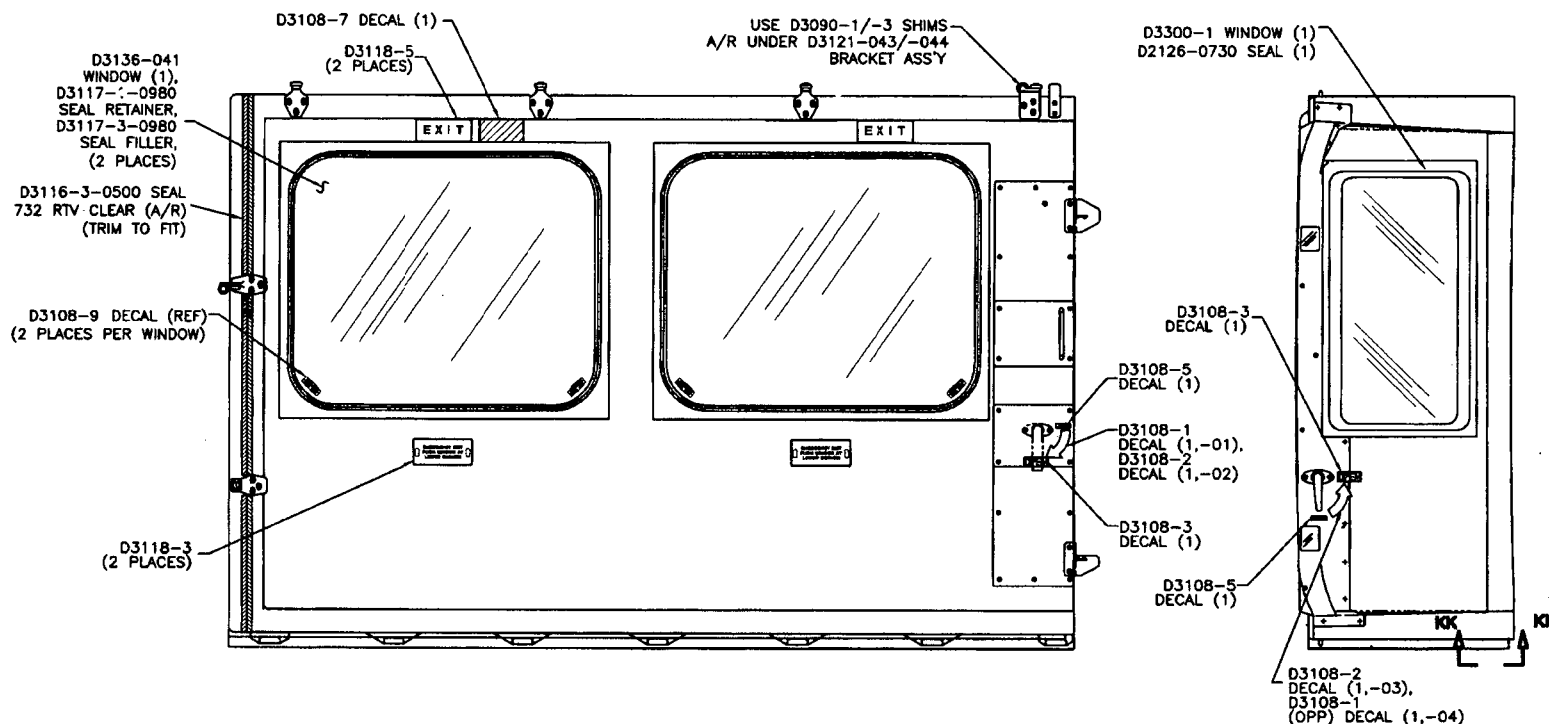
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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FIGURE 2: Decal Installation



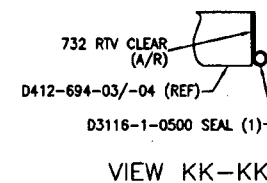
D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)

VIEW LOOKING • INSIDE OF DOOR

D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP.)

VIEW LOOKING • INSIDE OF DOOR

NOTE: THE PARTS LABELLED IN THIS DIAGRAM ARE INSTALLED BY THE CUSTOMER AFTER PAINT.
ALL OTHER PARTS COME PRE-ASSEMBLED ON THE DOOR.



SHOWN
REF
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WITHOUT FURTHER
WORK ORDER
NO. 70705-4.2.5
12/01/13

Revision: B
Date: 04.10.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

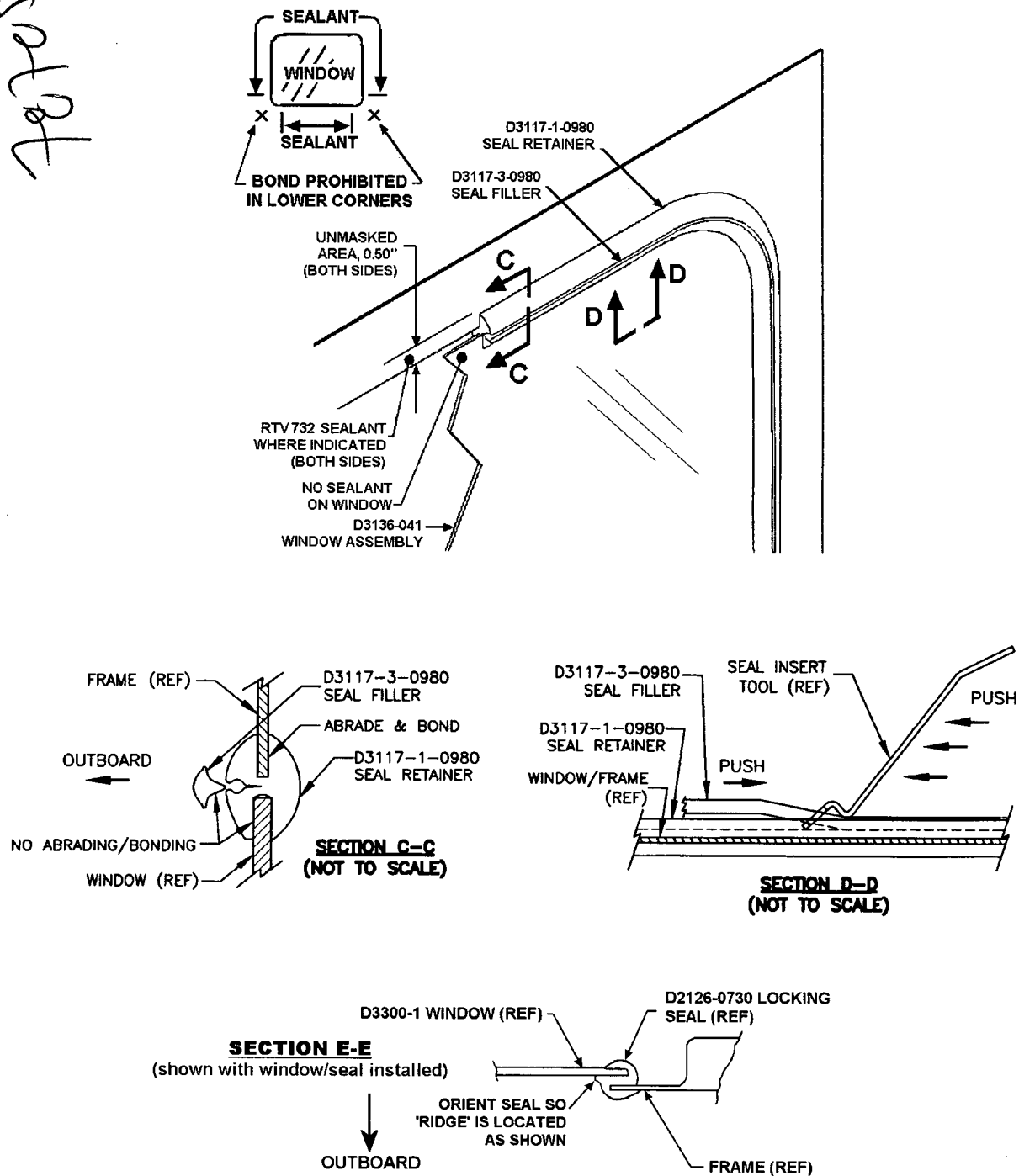


FIGURE 3: window/Seal Installation, (D412-694-01/-02 Door Assembly)

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Date: 04.10.07

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

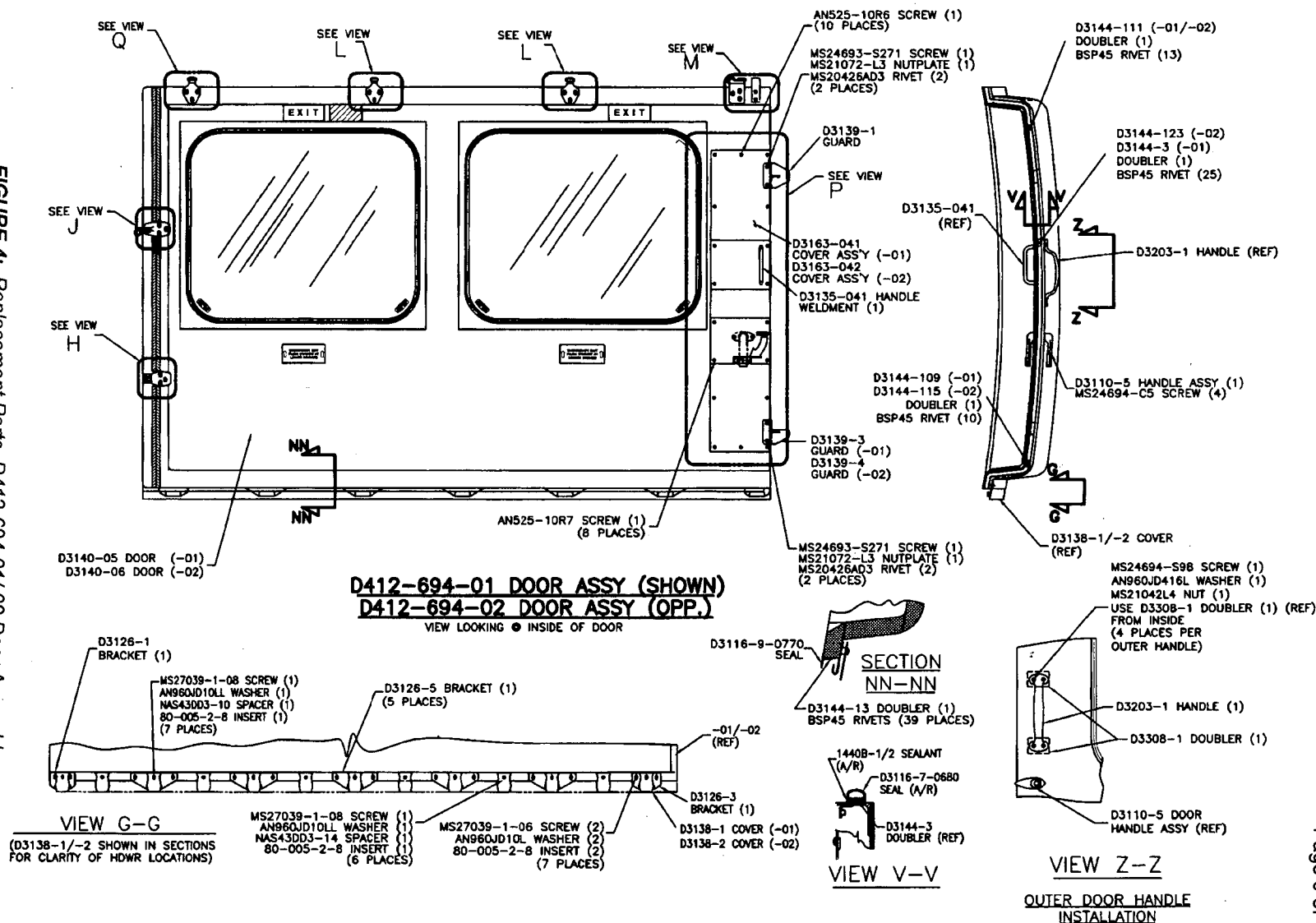
FIGURE 4: Replacement Parts, D412-694-01/-02 Door Assembly

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Métaux Castle / Castle Metals

D3126-3

x1

bracket

MS27039-1-08

x1

screw

B128636

AN9605D10LL (NAS1149D0316J)

x1

washer

B127993

NAS43003-10

x1

spacer

B19347

D3139-1

x1

guard

B110721

MS24693-S271

x2

screw

B14478